

## D1-4 Chuck/Face Plate Installation

**Product Identification:** 3- or 4-Jaw Chuck or 6" Face Plate for 15L Slant-PRO lathe

**Purpose:** The purpose of this document is to detail the installation of the 3- or 4-Jaw Chuck or the 6" Face Plate on the 15L Slant-PRO Lathe.

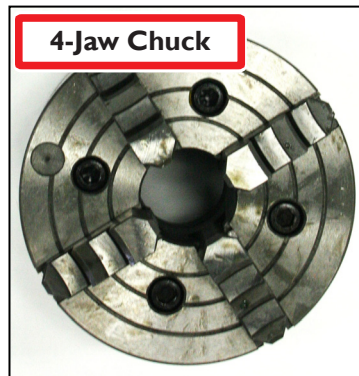
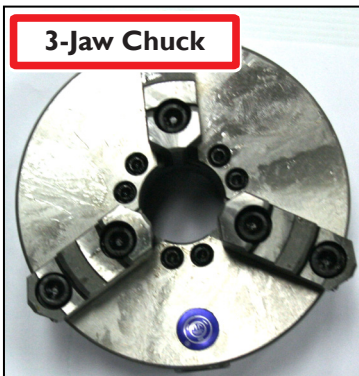


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view installation  
video.

*Check to ensure you have all the specific jaw parts before starting modifications:*

Qty	3-Jaw Chuck (PN 33156)	4-Jaw Chuck (PN 33336)	6" Face Plate (PN 34106)
1	3-Jaw Chuck	4-Jaw Chuck	6" Face Plate
1	Chuck Key	Chuck Key	—
1	Allen Wrench	Allen Wrench	—
3	Retention Studs	Retention Studs	Retention Studs
3	5mm Socket Head Cap Screws	5mm Socket Head Cap Screws	5mm Socket Head Cap Screws

**NOTE:** If any of these items are missing, contact Tormach Customer Service at (608) 849-8381 to obtain a replacement.



## Chuck Installation

1. Screw the three *Retention Studs* into the back of the chuck (see **Figure 1**).

**NOTE:** When properly installed, the *Retention Studs* should be at a depth where the *Gauge Line* is flush with the chuck (see **Figures 1 and 2**).

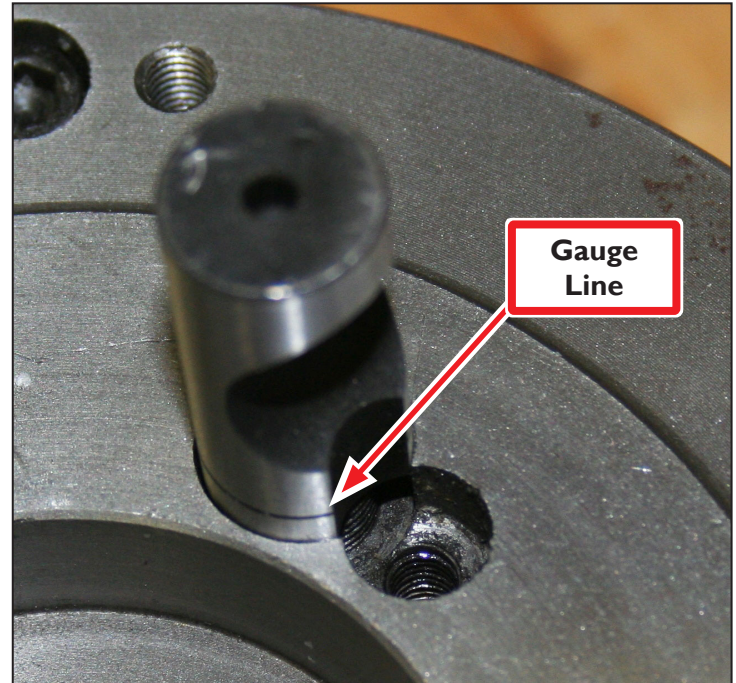


Figure 1

2. Make sure the groove in the side of each *Retention Stud* is lined up with the matching counter bore (see **Figure 2**).

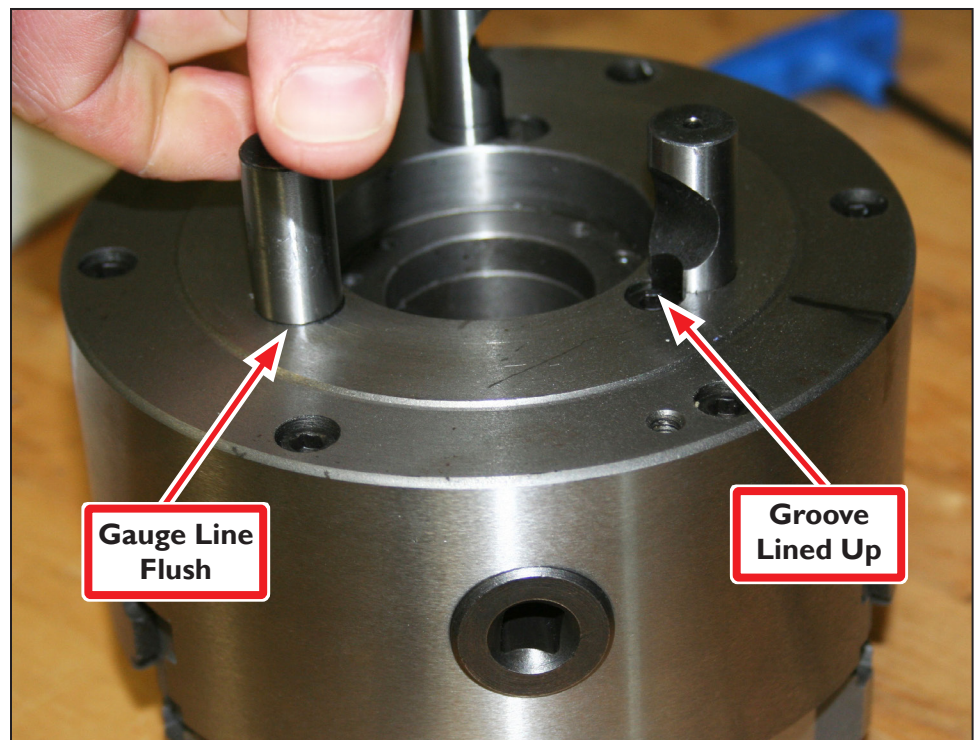
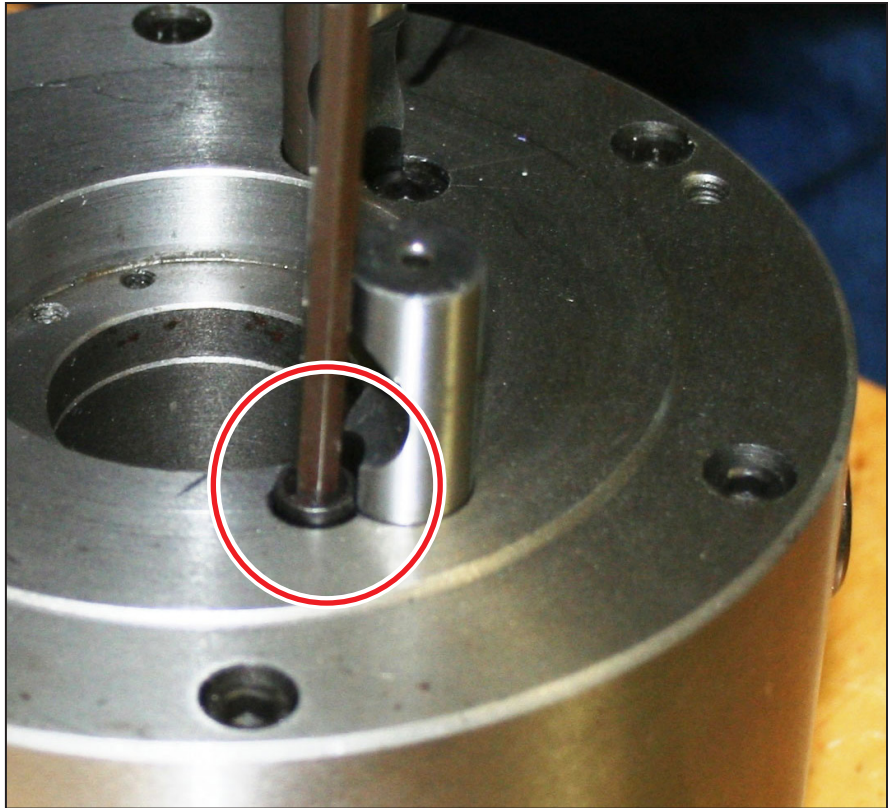


Figure 2

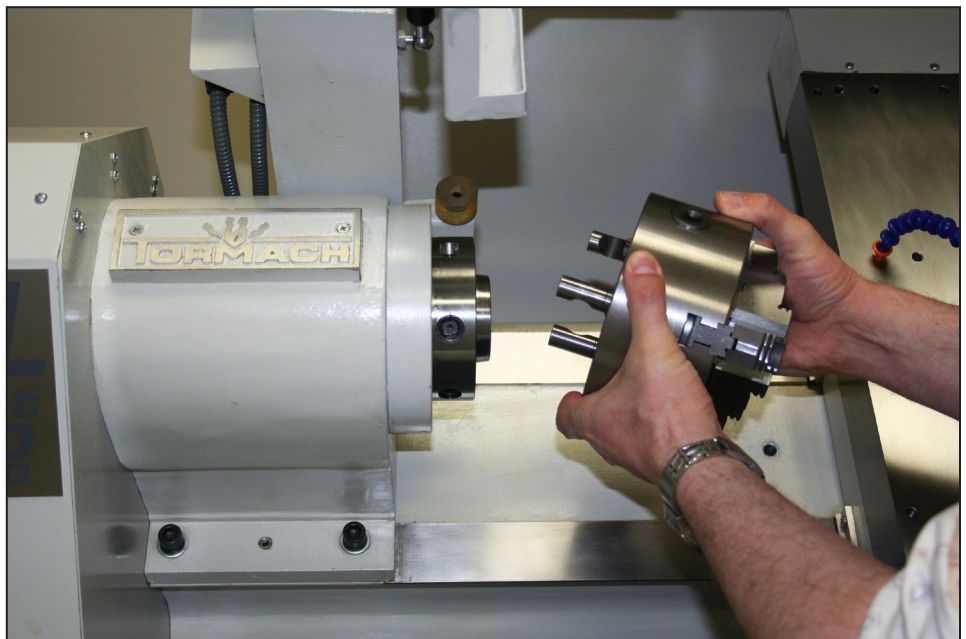


3. To lock the *Retention Studs* in the correct position, use a 5mm Allen wrench to tighten each stud with a *Socket Head Cap Screw* (see **Figure 3**).



**Figure 3**

4. Press the E-stop button to disable the spindle.
5. Install the chuck, ensuring the *Retention Studs* are lined up with the corresponding cam holes (see **Figure 4**).



**Figure 4**

## Locking the Chuck

- I. To lock the chuck, use the *Chuck Key* to turn each *Cam Lock* clockwise until the *Witness Mark* lands between the 3 o'clock and 6 o'clock positions (see **Figures 5 and 6**). To unlock and remove the chuck, rotate each *Cam Lock* to the 12 o'clock position (see **Figure 6**).



**WARNING! Ejection Hazard:** Do not operate spindle unless chuck is tightly locked in position and Chuck Key is removed. Failure to do so may result in severe damage to machine and cause personal injury.



Figure 5

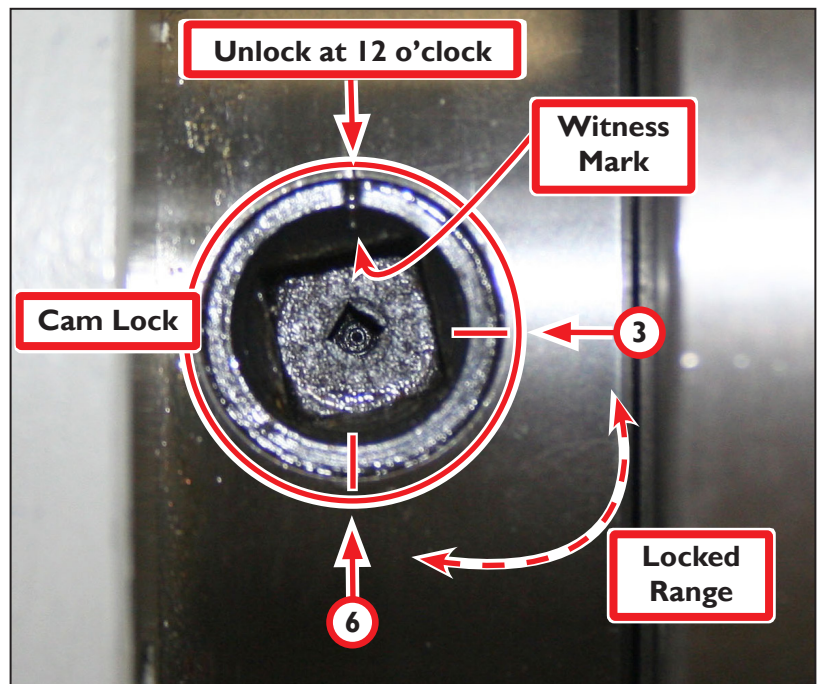


Figure 6



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# Technical Document

## Fine Tuning the Cam Locks

**Past 6 o'clock:** If the *Cam Lock Witness Mark* rotates past the 6 o'clock position, the *Retention Stud* has not been screwed in far enough. To fix the problem, unlock the three cams and remove the chuck. Remove the *Socket Head Cap Screw* on the *Retention Stud* in question. Rotate the stud clockwise one revolution. Re-tighten the *Retention Stud's Socket Head Cap Screw* and reinstall the chuck.

**Before 3 o'clock:** If the *Cam Lock Witness Mark* does not rotate past the 3 o'clock position, the *Retention Stud* has been screwed in too far. To fix the problem, unlock the three cams and remove the chuck. Remove the *Socket Head Cap Screw* on the *Retention Stud* in question. Rotate the stud counter clockwise one revolution. Re-tighten the *Retention Stud's Socket Head Cap Screw* and reinstall the chuck.

## Unlocking the Chuck

1. Press the E-stop button to disable the spindle.
2. Use the *Chuck Key* to turn each cam lock counter clockwise until the witness mark lands at the 12 o'clock Position (see **Figure 6**).
3. Remove the chuck with two hands as seen in **Figure 4**.